

SPLIT-

Work Order ID 82286-2

March-28-12 12:54:08 PM

82286

Page 1

Item ID: D4436-041

Revision ID:

Item Name: Aft Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

Required Date: 11/04/2012 Req'd Qty: 6.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

6

6

Approvals: Process Plan: MLJ

QC:

Date: 12/03/29 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D4436

A

100

100

Small Fab

Small Fab

Memo

Assemble as per dwg and intall grommet

0.00

0.00

2 φ

FT
1206-13

110

110

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

②

8
12/06/13

160

160

Packaging

Packaging

Identify as per dwg & Stock Location: 31441

Memo

0.00

0.00

2

5 ac 12/06/13

Work Order ID 82286

March-28-12 12:54:08 PM

82286

Page 2

Item ID: D4436-041

Revision ID:

Item Name: Aft Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

Required Date: 11/04/2012 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

170

170

QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

0.00

Memo

0.00

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

12/6/14 JF

MF
12-06-13⁰

Print

March-28-12 12:54:11 PM

Page 1

Work Order ID: 82286

82286

Parent Item: D4436-041

D4436-041

Parent Item Name: Aft Bracket Assembly

Start Date: 28/03/2012

Required Date: 14/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VER:EC
RevB 11.12.22 per PA2 EC verified by:JLM
12.01.24 PER DWG REV:A DD VER:EC

IPP
IPP REV:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4440-1

Manufactured

No

100

Each

80.0000

1

6

**

D4440-1

Grommet

Location

Loc Qty

Loc Code

GA

77

80645

77

prelim

2

74759

2

ST139F

1

79372

1

D4435-043

Manufactured

No

100

Each

3.0000

1

6

**

D4435-043

Mount Bracket Assembly

Location

Loc Qty

Loc Code

ST

-7

79612

3

ST139E

10

D4436-043

Manufactured

No

100

Each

0.0000

1

6

D4436-043

Aft Outboard Bracket Assembly

D4436-045

Manufactured

No

100

Each

1.0000

1

6

**

D4436-045

Aft Inboard Bracket Assembly

Location

Loc Qty

Loc Code

GA

1

80760

1

082288

1

2

FF 12-06-13

Picklist Print

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Page 2

Work Order ID: 82286

Parent Item: D4436-041

Parent Item Name: All Bracket Assembly

82286

D4436-041

Start Date: 28/03/2012

Start Qty: 6.00

Required Date: 11/04/2012

Required Qty: 6.00

AN525-832R6

Purchased

No.

100

Each

343.0000

4

24

AN525-832R6

**

Screw

Location

Loc Qty

Loc Code

ST345

343

120308

1

120560

342

② FF 12-06-13
D

March-28-12 12:54:11 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

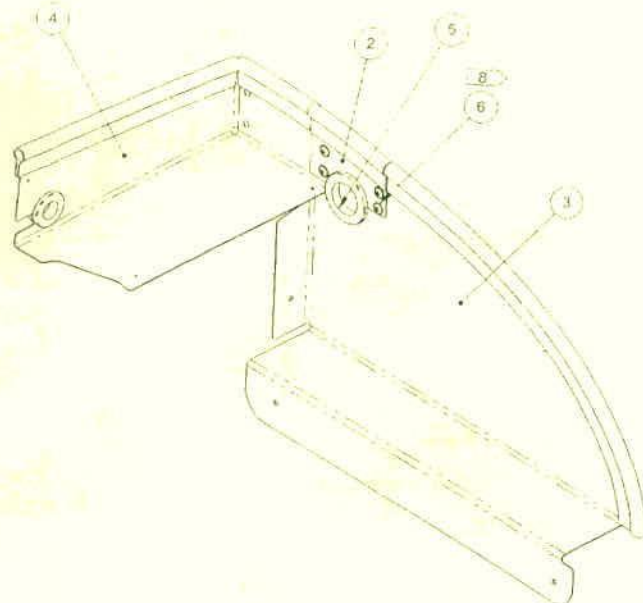
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D4436-041	AFT BRACKET ASSEMBLY
2	1	D4435-043	BRACKET ASSEMBLY
3	1	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
4	1	D4436-045	AFT INBOARD BRACKET ASSEMBLY
5	1	D4440-1	GROMMET
6	4	AN525-832R6	SCREW



D4436-041 AFT BRACKET ASSEMBLY

REVISION
 REVISION
 REVISION
 UNCONTROLLED REVISION
 SUBJECT TO CHANGE
 WITHOUT NOTICE
 WORK ORDER

NO. 82286 MCT
 12/03/20

12/03/20
 2012-01-23
 MCT

A		NEW ISSUE	
REV	DESCRIPTION	RF	12/01/17
DESIGN	RF	BY	DATE
DRAWN	RF	DART AEROSPACE LTD	
CHECKED	RF	HAWKINSBURY, ONTARIO, CANADA	
MFG. APPR.	RF	DRAWING NO. D4436	
APPROVED	RF	TITLE	
DE APPR.	RF	COVER ASSEMBLY	
DATE	12.01.17	SHEET 1 OF 7	
		SCALE	
		NTS	

SERIAL: N/A
 SH: N/A
 DIMENSIONS: PER DART QSI 018 UNLESS OTHERWISE NOTED
 TOLERANCES: UNLESS OTHERWISE NOTED
 SURF. FINISH: UNLESS OTHERWISE NOTED
 SURF. TREATMENT: UNLESS OTHERWISE NOTED
 WEIGHT: 1.31 lbs
 MATERIAL: ALUMINUM 6061-T6
 FINISH: ANODIZED
 QUOTE: SCREW TO 12-15 (in-lb)

8 7 6 5 4 3 2 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

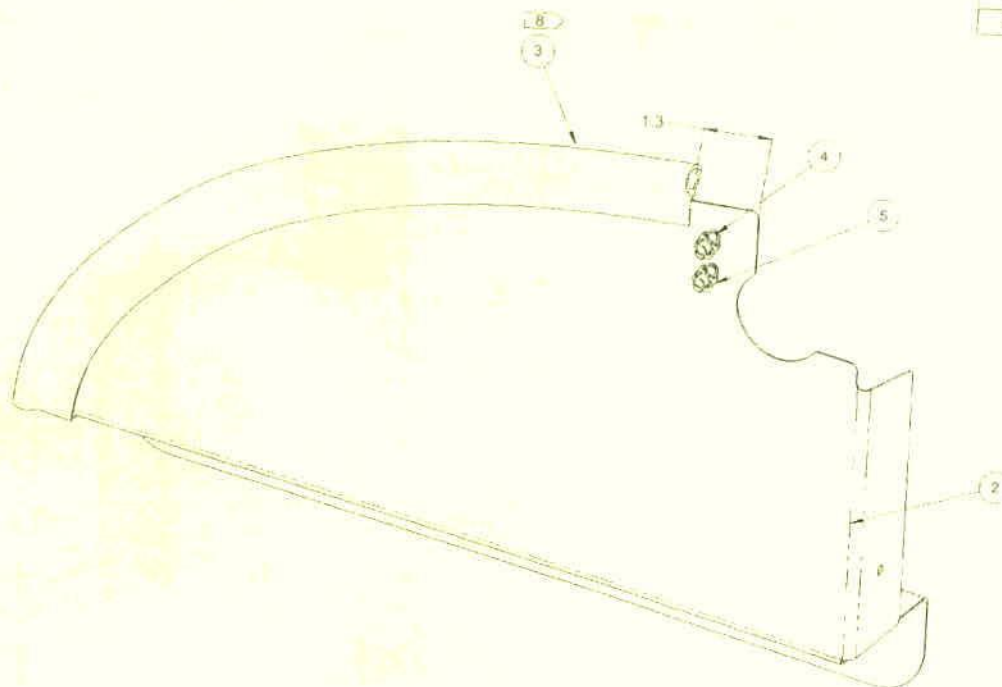
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -043	PART NUMBER	DESCRIPTION
	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	MS20426AD3-2	RIVET
5	2	MS21075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE



D4436-043 AFT OUTBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3 MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4436 TITLE COVER ASSEMBLY SCALE NTS <small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. NO PART OF THIS DOCUMENT IS TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>
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APPROVED	SP	
DE APPR	SP	
DATE	12.01.17	

2012-01-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

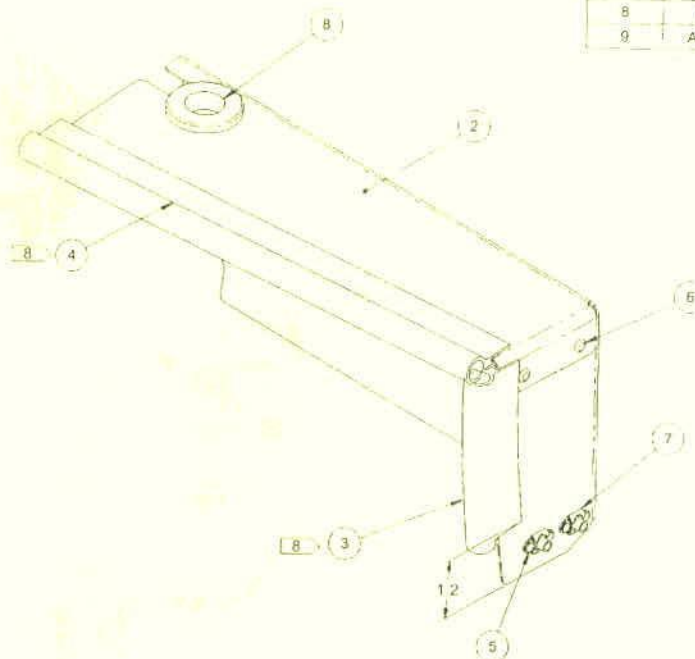
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-038	RUBBER SEAL
4	1	D4441-1-190	RUBBER SEAL
5	4	MS20476AD3-2	RIVET
6	2	MS20470AD4-3	RIVET
7	2	MS21075L88	NUT PLATE
8	1	MS35489-79	GROMMET
9	A/R	3M 1300/1300L	ADHESIVE



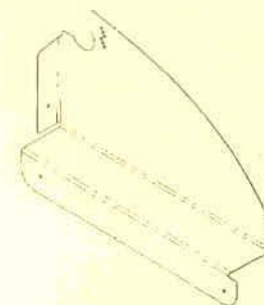
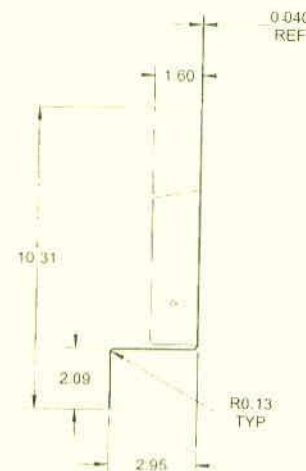
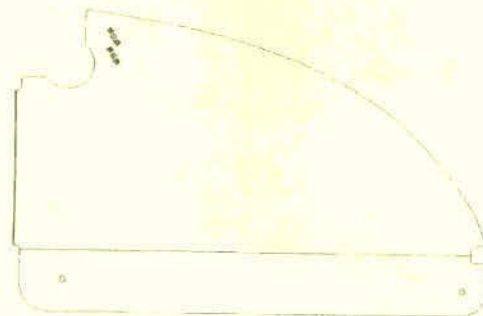
D4436-045 AFT INBOARD BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE;
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
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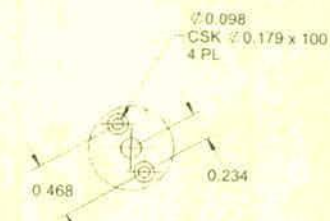
D4436-1 BRACKET

NOTES:

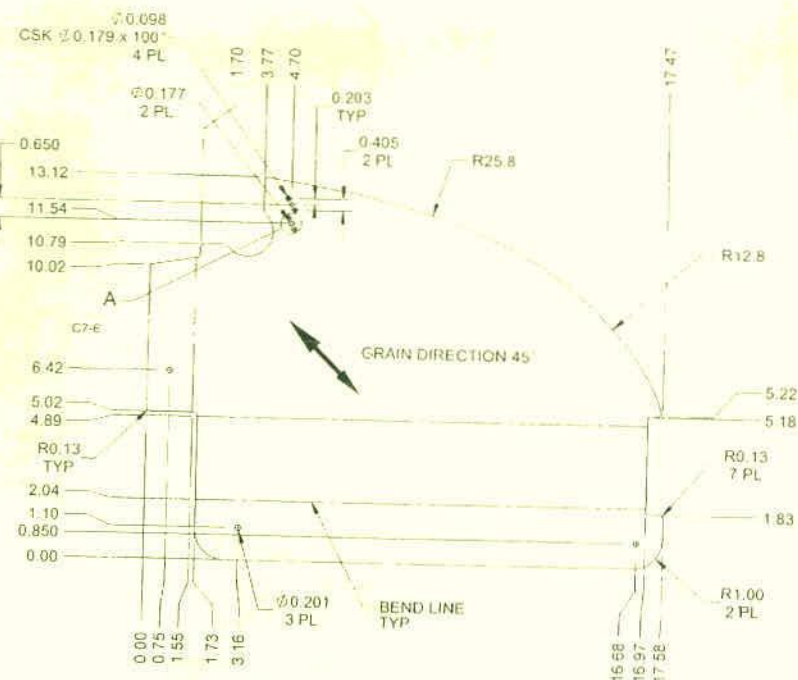
- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

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DE APPR.	RF		
DATE	12.01.17		

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DETAIL A C6-6
SCALE 4X, TYP



D4436-1F FLAT PATTERN

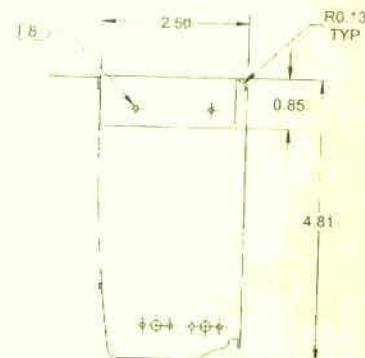
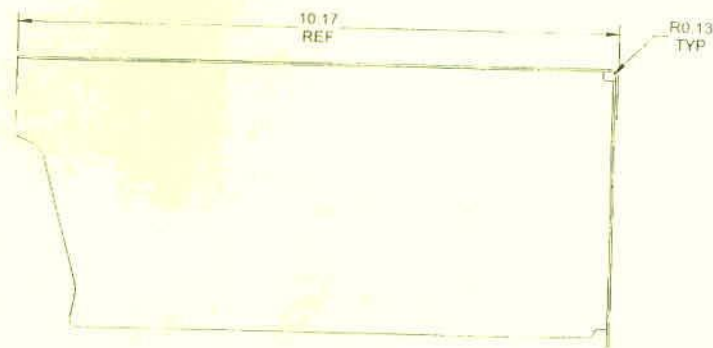
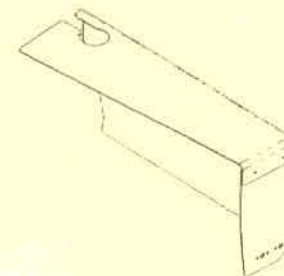
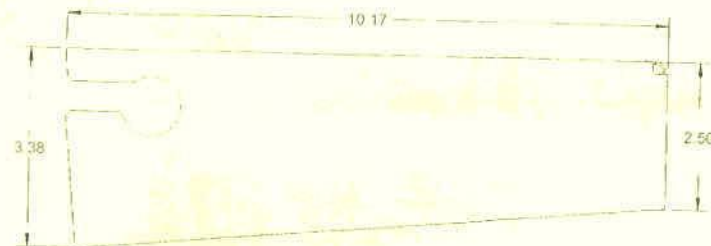
NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

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MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 7	
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DE APPR.	<i>[Signature]</i>	DATE 12.01.17	

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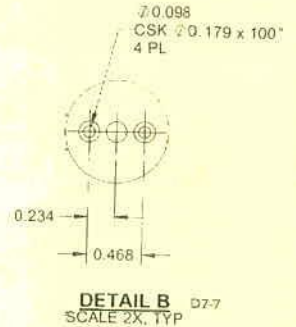
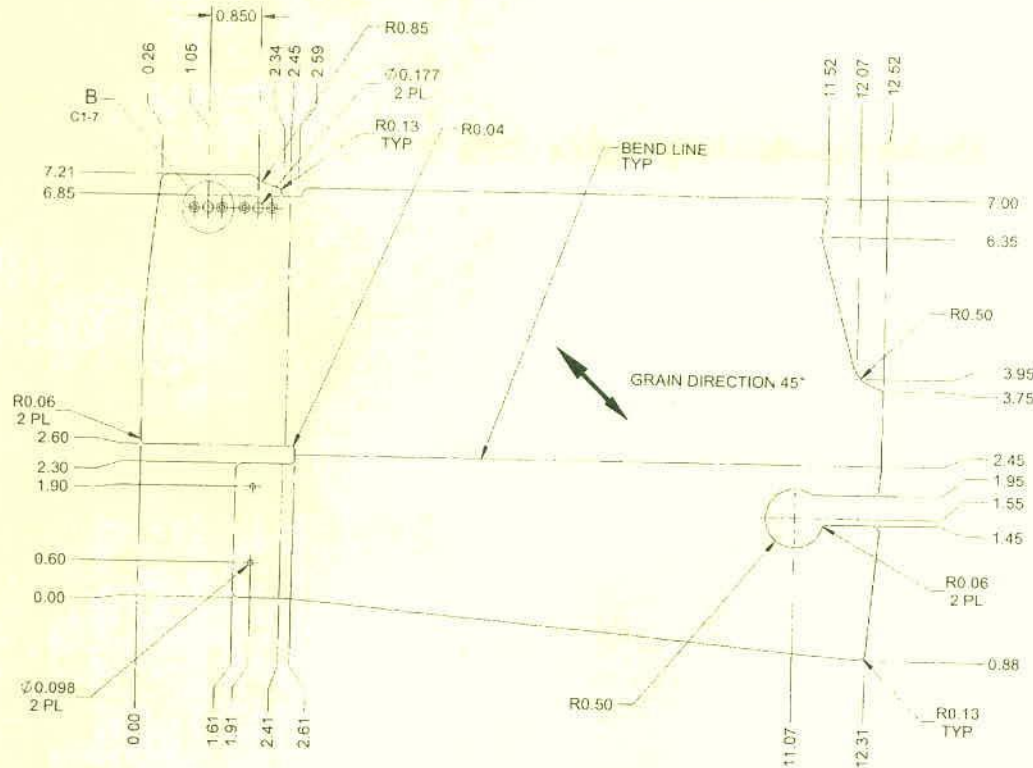
02206

D4436-3 BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) TRANSFER Ø0.129 HOLES THRU 2 PLACES

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 6 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
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D4436-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S 040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO	REV. A
MFG. APPR.	RF	D4436	SHEET 7 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	NTS
DATE	12.01.17	COPYRIGHT © 2017 BY DART AEROSPACE LTD	

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